


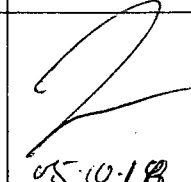


<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>23618</b>
<b>Description:</b> Hi - Step Leg Assembly	<b>Part Number:</b>	<b>D3065-041</b>
<b>Dwg:</b> D3065 Rev. <del>A1</del> <b>A2</b>	<b>Qty:</b>	<b>60</b> <del>57</del>
<del>RF 03.02.17</del> RF 03.02.28		Page 1 of 2

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller <i>Dwg. not required RF 02.11.04</i> (Minimum lots of 30)	<i>RF</i>	05.06.21	60
2	MV	Cut blanks: 3.600" x 4.500" (grain along 4.500") Material: 2024-T3 Sheet (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch <i>M17948</i> Identify as D3065-1 <i>4.320" RF 02.11.29 4.320"</i>	<i>YD</i>	05/08/08	60
3	MV	Cut blanks: 6.600" x <del>4.250"</del> (grain along <del>4.250"</del> <i>4.320"</i> ) <i>RF</i> Material: 2024-T3 Sheet (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch <i>M17948</i> Identify as D3065-3 <i>m</i>	<i>YD</i>	05/08/08	60
4	MV	Cut blanks: 4.580" x 4.500" (grain along 4.500") Material: 2024-T3 Sheet (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch <i>M17948</i> Identify as D3065-7	<i>YD</i>	05/08/08	60
5	MV	Cut blanks: 16.61" x 8.51" (grain along 8.51") for each leg. Material: 5052-H32 Sheet (QQ-A-250/8) 0.080" thick (M5052H32S.080) Batch <i>M17695</i> Identify as D3065-5 (Note: make 2 legs per assembly)	<i>YD</i>	05/08/08	120
6	MV	Cut blanks: 16.490" x 0.750" for each spacer. (-0.00/+0.010) Material: 5052-H32 Sheet (QQ-A-250/8) 0.080" thick (M5052H32S.080) Batch <i>M17695</i> Identify as D3066-1 (Note: make 2 spacers per assembly) <i>M17791</i>	<i>YD</i>	05/08/08	120
7	MV	Machine D3065-1 as per folio FA182 and Dwg D3065, use stack of 15.	<i>ml</i>	05/08/22	60
8	MV	Deburr to take measurement	<i>ml</i>	05/08/22	60
9	QC2	Inspect parts as they come off the CNC machine	<i>ml</i>	05/08/22	60
10	QC8	Second check	<i>Er</i>	05/08/22	60
11	MV	Machine D3065-3 as per folio FA180 and Dwg D3065, use stack of 15.	<i>ml</i>	05/08/22	60
12	MV	Deburr to take measurement	<i>ml</i>	05/08/22	60
13	QC2	Inspect parts as they come off the CNC machine	<i>ml</i>	05/08/22	60
14	QC8	Second check	<i>Er</i>	05/08/22	60
15	MV	Machine D3065-7 as per folio FA181 and Dwg D3065, use stack of 15.	<i>ml</i>	05/08/22	60
16	MV	Deburr to take measurement	<i>ml</i>	05/08/22	60
17	QC2	Inspect parts as they come off the CNC machine	<i>ml</i>	05/08/22	60
18	QC8	Second check	<i>Er</i>	05/08/22	60
19	MV	Machine D3065-5 as per folio FA179 and Dwg D3065, use stack of 10.	<i>/</i>	<i>/</i>	<i>/</i>

25.03.09  
#8

RELEASED  
02/11/04 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/10/04	28	2 Pieces D 3065-1 were over tolerance		Scrap des trous	05/10/04	 05-10-18	 05-10-04	 05-10-04

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:  Date: 05/10/18

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	23618
<b>Description:</b> Hi - Step Leg Assembly		<b>Part Number:</b>	D3065-041
RF 03.02.28			
<b>Dwg:</b> D3065 Rev. A1 A2		<b>Qty:</b>	60
RF 03.02.17		Page 2 of 2	

Step	Location	Procedure	By	Date	Qty																								
19	MV	Machine D3065-5 as per folio FA179 and Dwg D3065, use stack of 10.	me	05/08/21	120																								
20	MV	Deburr to take measurement	me	05/08/21	120																								
21	QC2	Inspect parts as they come off the CNC machine	me	05/08/21	120																								
22	QC8	Second check	EP	05/08/22	120																								
23	MV	Machine D3066-1 as per Folio FA280 and Dwg D3066, use stack of 10.	me	05/08/22	120																								
24	MV	Deburr to take measurement	me	05/08/22	120																								
25	QC2	Inspect parts as they come off the CNC machine	me	05/08/22	120																								
26	QC8	Second check	EP	05/08/22	120																								
27	GA	Deburr D3065-1, D3065-3, D3065-5, D3065-7 & D3066-1 stack. <del>120</del> 59 120 59 120	me	05/08/29	✓																								
28	GB	Bend D3065-1, D3065-3 & D3065-7 as per Dwg D3065 59 59 59	SB	05/10/04	59																								
29	QC5	Inspect work to Step 28	J	05-06-04	59																								
30	FP	Chemical conversion coat as per QSI 005 4.1 RF 02.11.06 D3065-1, D3065-3, D3065-5, D3065-7 & D3066-1	SB	05/10/05	59																								
31	GA	Assemble as per Dwg D3065 and identify as D3065-041 Assembly. <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3065-1</td><td>Spacer</td><td>B23618</td></tr><tr><td>1</td><td>D3065-3</td><td>Spacer</td><td>B23618</td></tr><tr><td>2</td><td>D3065-5</td><td>Leg</td><td>B23618</td></tr><tr><td>1</td><td>D3065-7</td><td>Spacer</td><td>B23618</td></tr><tr><td>30</td><td>MS20470AD4-4</td><td>Rivet</td><td>M17425</td></tr></table>	Qty	Part Number	Description	Batch	1	D3065-1	Spacer	B23618	1	D3065-3	Spacer	B23618	2	D3065-5	Leg	B23618	1	D3065-7	Spacer	B23618	30	MS20470AD4-4	Rivet	M17425	SB	05/10/18	57
Qty	Part Number	Description	Batch																										
1	D3065-1	Spacer	B23618																										
1	D3065-3	Spacer	B23618																										
2	D3065-5	Leg	B23618																										
1	D3065-7	Spacer	B23618																										
30	MS20470AD4-4	Rivet	M17425																										
32	QC5	Inspect work to Step 31	J	05-10-18	57																								
33	GA	Identify and Stock D3065-041 Hi-Step Leg Assembly D3066-1 Spacer	J	05-10-18	57																								
34	AC	Cost / part 39.11	SUC	05-10-19	57																								
35	DC	Close W/O 39.64 Inspect Level 21	EP	05/10/18	57																								

Rev	Date	Change	Revised By	Approved
A	01.12.10	New Issue	SM	
B	02.09.10	Re-format; Incorporated D3065-1/-3/-5/-7	KJ	
C	02.11.01	Incorporated D3066-1 IPP	KJ RF	#

RELEASED  
02/11/04 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
05-10-18	31	5.44 5.44 5.44 6x D3065-5; 2x 3065-7; 2x -3 left over. place in overstock, identified in <u>WA</u>	<i>[Signature]</i>	05-10-18			<i>[Signature]</i> 05-10-18

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_





H:\FORMS\Quality Assurance\approved QA\FAI revD







# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Jun 20, 2005  
03:23 pm

Work Order No : 0023618  
Project Name : D3065-041  
Project For : WK530  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3065-041  
Description : Step Leg Assembly  
Manufactured : Yes  
Amount Req'd : 60  
Amount Done : 0  
Start Date : 06-20-05  
Est Finish Date : 07-30-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00